

Having thus described the invention, what I claim is:

1. A method of filling and sealing a gas capsule having (i) a hollow body portion and (ii) an elongate hollow neck portion having a free open distal end extending from the body portion, comprising the sequential steps of:

5 a) applying in a fluid tight manner a filling cap to the free open distal end of the neck portion, initially evacuating the hollow body portion via the filling cap and subsequently filling the hollow body portion with helium under a pressure of at least 30 bar;

10 b) with the filling cap still in place and pressure still applied to the helium, making a first crimp in the elongate hollow neck portion at a portion spaced from the open distal end of the neck portion, the first crimp preventing significant leakage from the hollow body portion of the capsule past the first crimp when the filling cap is removed;

15 c) removing the filling cap thereby revealing again the free distal end of the elongate hollow neck portion; and

20 d) applying a second crimp at or immediately adjacent the free distal end of the elongate hollow neck portion, thereby creating a chamber between the first and second crimps;

25 and also comprising the additional step of welding the free distal end of the elongate hollow neck portion at substantially the same time as the second crimp is formed and thereby hermetically sealing the capsule without severing the hollow elongate neck portion.

2. The method of claim 1, wherein the said capsule is made from aluminium or an aluminium alloy.
3. The method of claim 1, when said step of welding is a step of laser welding.
4. The method of claim 1, wherein the said pressure is greater than 30 bar and less than 80 bar.